

Work Order ID 67602-2

Monday, March 28, 2011 2:27:30 PM



Page 1

Item ID: D3290-3

Revision ID:

Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID:  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATERJET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290  
Debur if necessary

Dwg Rev

Prog Rev

2-

110

0.00



QC2- Inspect parts off machine F&M MB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

RECALL

RECEIVE

AUTHN

DATE

DATE

# Work Order ID 67602

Monday, March 28, 2011 2:27:30 PM

Page 2

Item ID: D3290-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin! remove sharp edge by degurring.

x18

11/04/11

140

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 □ Dwg.  
Rev. C □ Folio Rev B □ 2-Engrave part# &  
batch#, (D3290-3)

x18

11/04/11

150

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

x18

11/04/11

# Work Order ID 67602

Monday, March 28, 2011 2:27:30 PM

Page 3

Item ID: D3290-3

Accept

Revision ID:

Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				12	11	04	11/04/11
170 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING  Memo Water sand and buff to remove scratches if required	0.00  0.00				718			11/04/11
180 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				418			



# Picklist Print

Monday, March 28, 2011 2:27:37 PM

Page 1

Work Order ID: 67602

Parent Item: D3290-3

Parent Item Name: Window



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 04.08.18 New issue KJ/RFF  
 IPP B 06.05.09 Ecn 798 EC  
 IPP C 07.05.29 Thermoform in-house DL  
 IPP D 07.09.28 rev C dwg EC verified by: DD  
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased	No			100	sf	10.0000	3	<del>37.89474</del> 37.89474	64		
1/8" Polycast II Sheet													

KB11-4-8

Location	Loc Qty	Loc Code
MAT019	10	
115338	10	
117340		

117340

(18)





SHOOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 4-1602

FWD  
INBOARD

D2126-0780 LOCKING SEAL  
(TRIM TO FIT)  
D3290-1 WINDOW FRAME  
D3290-3 WINDOW

1.10 (TYP)  
DIST. FROM FRAME  
EDGE TO WINDOW

D2126-0780 LOCKING SEAL  
(REF)

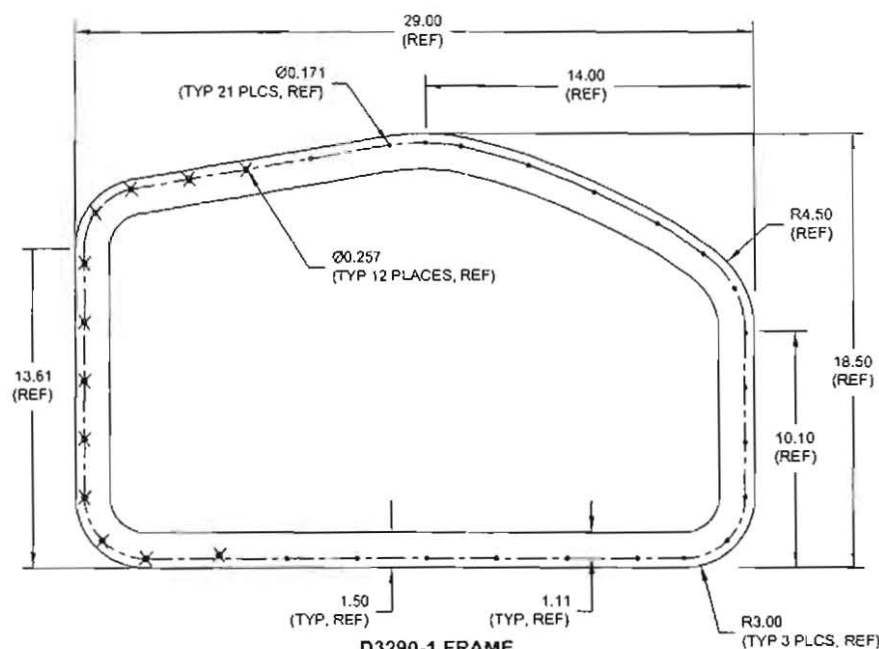
ENSURE D3290-3 WINDOW IS INSTALLED  
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

SECTION A-A  
NTS

### D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:  
1) WEIGHT: 3.68 LBS

GENERAL NOTES:  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED



### D3290-1 FRAME

#### D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4 5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED  
07.07.24  
DEO ATTACHED

UNDER REVIEW

07.07.24

07.07.24

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 028	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

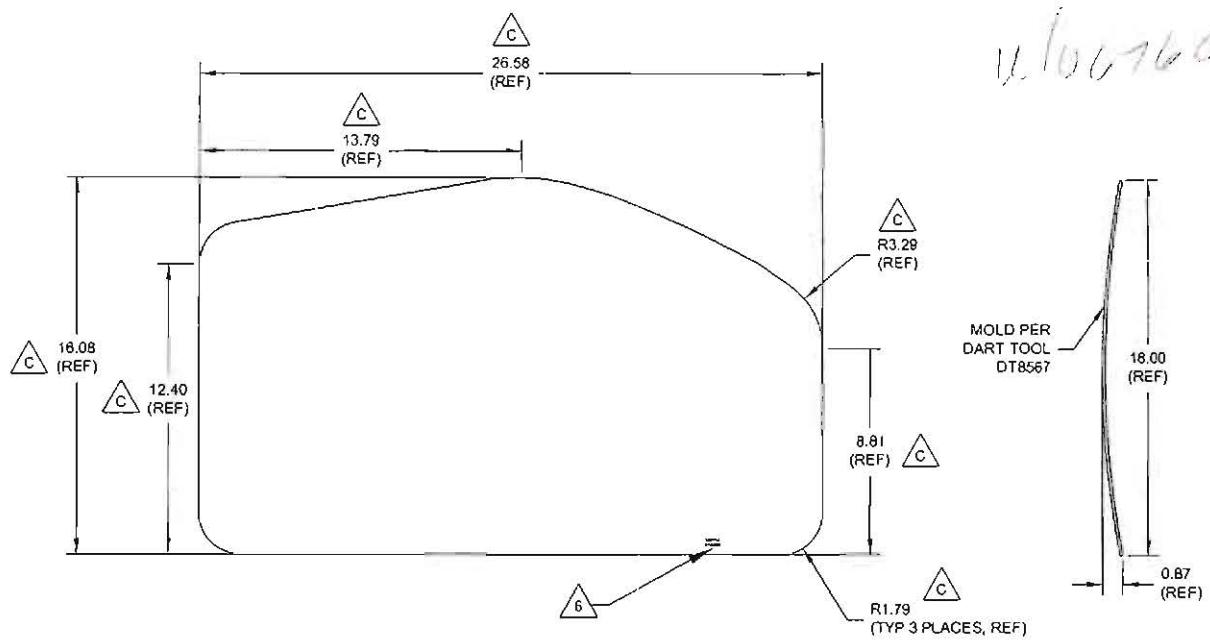
DRAWING NO. D3290  
REV. C  
SHEET 1 OF 2

TITLE  
REPLACEMENT WINDOW ASSEMBLY  
SCALE  
1:5

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8 7 6 5 4 3 2 1

11/06/602



**D3290-3 WINDOW**

**D3290-3 NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S 125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

*W. Perlick*  
**UNDER REVIEW**  
*11/06/602*  
**DEO ATTACHED**  
**RELEASED**  
*07.07.22*

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD This document is the property of Dart Aerospace Ltd. It is to be used for the purpose intended and only for the project for which it was prepared. It is not to be reproduced, stored in a retrieval system, or transmitted in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without the prior written permission of Dart Aerospace Ltd.</small>

8 7 6 5 4 3 2 1



DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>1</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>#</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

**PURPOSE:**

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

**CHANGE:**

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

*u/o 47602*

**D3290-1 NOTES**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)  
 OR  
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/8 OR AMS 4016  
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

**RELEASED**  
 2009-10-09  
*WTP*

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